

SHIP 19/01

Dart Aerospace Ltd.

Date: Thursday, 18/01/2007 3:18:05 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 30320
 Estimate Number : 10372
 P.O. Number : N/A
 This Issue : 18/01/2007 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : MACHINED PARTS
 Previous Run : 29828
 Written By :
 Checked & Approved By :
 Comment : Est. A04.02.09 New issue KJ/DS

Drawing Name : BOLT
 Part Number : D312121
 Drawing Number : D3121 REV D
 Project Number : N/A
 Drawing Revision : D
 Material : N/A
 Due Date : 19/01/2007
 Qty: 50 Um: Each

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : | | |
|---------|-----------------------|---|-------------|----|
| 1.0 | M303H0500 | 303 HEX BAR | | |
| | | | | |
| | | Comment: Qty.: 0.0417 f(s)/Unit Total : 2.0850 f(s) 303 HEX BAR Material: AISI 303 SS 1/2" Hex Bar (M303H0.500) Batch: 102286 | | |
| 2.0 | HARDINGE | HARDINGE CNC LATHE SMALL | RG 07-01-19 | 50 |
| | | | | |
| | | Comment: HARDINGE CNC LATHE SMALL 1-Turn D3121-21 2-Identify as D3121-21 3-Deburr break all sharp edges 0.005" to 0.010" | | |
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE | RG 07-01-19 | 50 |
| | | | | |
| | | Comment: INSPECT PARTS AS THEY COME OFF MACHINE | | |
| 4.0 | QC8 | SECOND CHECK | RG 07-01-19 | 50 |
| | | | | |
| | | Comment: SECOND CHECK | | |
| 5.0 | PACKAGING 1 | PACKAGING RESOURCE #1 | JF 07/01/19 | 50 |
| | | | | |
| | | Comment: PACKAGING RESOURCE #1 Identify and Stock Location: N/A | U 07-01-19 | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 18/01/2007 3:18:05 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BOLT

Job Number: 30320

Part Number: D312121

Job Number:



Seq. #: **Machine Or Operation:**

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

18/01/19

Job Completion



u 07.01.19

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

| | | |
|-----------------------|--------------|-------------|
| DART AEROSPACE LTD | Work Order: | 30320 |
| Description: Bolt | Part Number: | D3121-21 |
| Inspection Dwg: D3121 | Rev: D | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

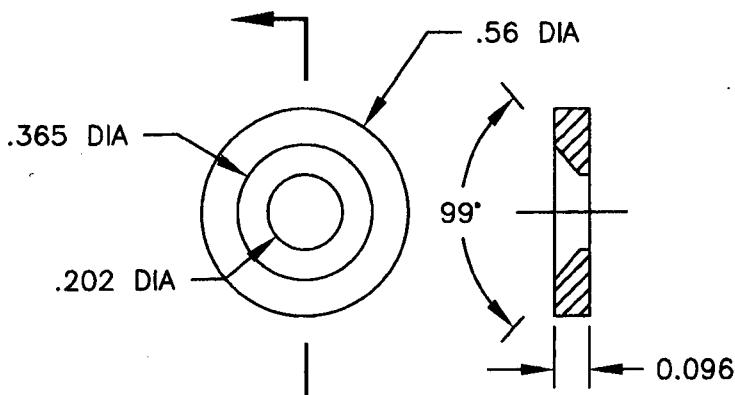
X First Article Prototype

| | | |
|------------------------|-----------------------|-------------------------|
| Measured by: <u>SG</u> | Audited by: <u>SA</u> | Prototype Approval: N/A |
| Date: 03.01.19 | Date: 01.01.19 | Date: N/A |

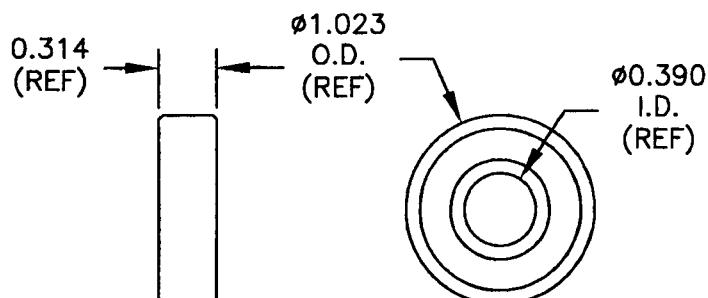
| Rev | Date | Change | Revised by | Approved |
|-----|----------|------------------|------------|----------|
| A | 04.02.27 | New Issue | KJ/RF | |
| B | 06.03.09 | Dwg Rev. updated | KJ/JLM | |
| C | 06.06.14 | Dwg Rev. updated | KJ/JLM | ✓ |

DART

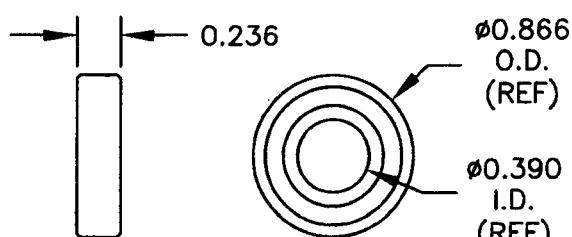
| | | | |
|----------|----------|--------------------|-----------------------------|
| DESIGN | DRAWN BY | DART AEROSPACE LTD | |
| CHECKED | APPROVED | CB | HAWKESBURY, ONTARIO, CANADA |
| DATE | | DRAWING NO. | REV. D |
| 06.05.17 | | D3121 | SHEET 10 OF 10 |

**D3121-17 WASHER (SCALE 2:1)**

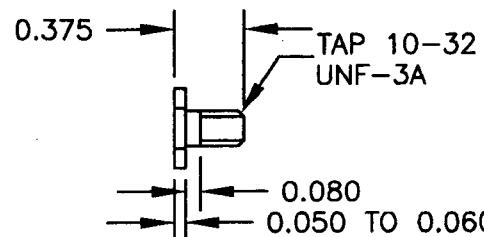
- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-19 BEARING (SCALE 1:1)**

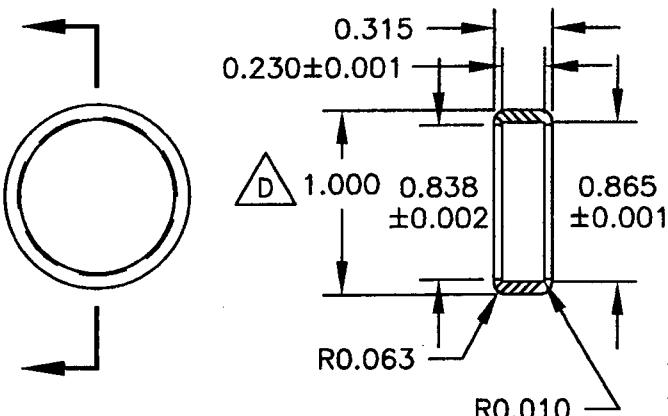
- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM
FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-23 BEARING (SCALE 1:1)**

- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z
OR KML P/N 6900-2Z
- 2) ALL DIMENSIONS ARE IN INCHES

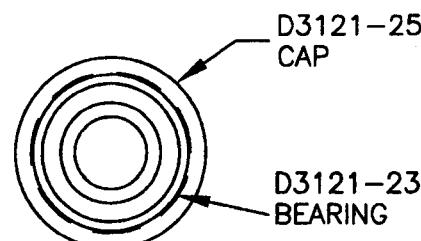
**D3121-21 BOLT (SCALE 1:1)**

- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-25 CAP (SCALE 1:1)**

- 1) MATERIAL: DELRIN ROD, Ø1.25 (REF DART SPEC. M-DELRIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

RELEASED

**D3121-241 BEARING ASSEMBLY (SCALE 1:1)**